

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.21**WELDING WITNESS REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000415**Date Inspected:** 23-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**Witness:** **Procedure Qualification Record**
Welding **NDT****Welder Qualification** **Fracture Critical**
Mechanical Testing, describe:**Index Lot #:** B-22-025-07**Witness Lot #:** B22-025-07**Bridge No:** 34-0006**Component:** Bid item 52,55 Tower & Girder**Welder:** Zhuhai Ping**ID #:** na**Joint Description:** B-U2a

N/A

WPS ID #: PWPS-B-T-3213

N/A

Base Metal: A709 Gr HPS485WT2/Z

N/A

PQR ID #: HP20077149-1

N/A

Thickness: 90mm

N/A

Process: SMAW

N/A

Electrode Spec/Class: AWS-A5.1/E-7018-1

N/A

Positions: 3G

N/A

Backing Material: A709 Gr HPS485W

N/A

CWI: Ye Young Jun and Huang Wei

N/A

Average Amps: 166.8

N/A

AWS Code: AWS D1.5 (2002)

N/A

Average Volts: 22.8

N/A

Applicable Sec: AWS 5.13

N/A

Travel Speed: 80.6

N/A

Heat Input: 2.83

N/A

Preheat: 172°C

N/A

Summary of Items Observed:

Quality Assurance (QA) Inspector Brannon was present as requested to witness the welding of the Procedure Qualification Record(PQR) test plate HP 2007149-1 using the shielded metal arc welding (SMAW) electrode specification/classification A5.1, diameter of electrode 4.0 mm in the 3-G position. The welding was performed per the AWS D1.5, Section 5.13 Production Procedure WPS. Total of passes/layers were 70 passes and 22 layers.

The welding on test coupon appeared to be in compliance with the contract documents.

Summary of Conversations:

No significant conversations on this date.

Observed welding,testing or results:

is in general conformance with the contract requirements.

is not in conformance with the contract requirements.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

WELDING WITNESS REPORT

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Inspected By: Brannon, Sherri

Quality Assurance Inspector

Reviewed By: Cuellar, Robert

QA Reviewer